

Work Order ID 69931

Page 1

Tuesday, May 24, 2011 2:24:15 PM

Item ID: D3535-15

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 5/24/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date: 11-05-24 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr	
D3535	Rev B	

100



FLOW WATER JET

Waterjet

Memo

0.00

B11-6-1

FLOW CNC Waterjet

304.040

1-Cut as per Dwg D3535

 Dwg Rev: B Prog Rev: B 2-

Deburr if necessary

110



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

B11-6-1

Quality Control

120



QC8- Inspect parts - second check

QC

Memo

0.00

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 2

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Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326 2-Form
joggle as per Dwg D3535 using Jig DT8158 3-Identify as D3535-15

S8 11/06/02

(14)

140



QC5- Inspect part completeness to step on W/O

0.00

S8 11/06/02

QC

Memo

0.00

Quality Control

150



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Memo

7:30

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:00

M115128

14x S8 11/06/06

W/O:		WORK ORDER CHANGES					
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Page 3

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Start Date: 5/24/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 5/31/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

14 BL 11-6-6.



QC

Memo

0.00

Quality Control

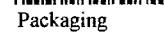
170

Identify as per dwg & Stock Location:

EP-18

0.00

14 BL 11-6-6



Packaging

Memo

0.00

180

QC21- Final Inspection - Work Order Release

0.00

11/6/11 JF



QC

Memo

0.00

Quality Control

11-06-06

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, May 24, 2011 2:24:22 PM

Page 1

Work Order ID: 69931



Parent Item: D3535-15



Parent Item Name: Wearshoe

Start Date: 5/24/2011

Required Date: 5/31/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased		No		100	sf	79.8814	1.0205	12.89053	14		

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT020	79.8814	
116623	0.2	
117550	79.6814	

117550

(14)

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DART AEROSPACE LTD		Work Order:	69931
Description: Wearshoe		Part Number:	D3535-15
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.888	✗		✓ B62	
2.000	+/-0.010	2.000	✗		✓	
5.650	+/-0.010	5.650	✗		T B61	
9.150	+/-0.010	9.156	✗		T	
14.400	+/-0.010	14.406	✗		T	
19.650	+/-0.010	19.656	✗		T	
24.900	+/-0.010	24.906	✗		T	
30.150	+/-0.010	30.156	✗		T	
33.650	+/-0.010	33.656	✗		T	
35.650	+/-0.010	35.656	✗		T	
39.150	+/-0.010	39.156	✗		T	
Ø0.188	+0.005/-0.001	.193	✗		✓	
24.00	+/-0.030	24.00	✗		T	
16.00	+/-0.030	16.00	✗		T	
8.00	+/-0.030	8.00	✗		T	
5.00	+/-0.030	5.00	✗		T	
0.300	+/-0.010	-3.03	✗		✓	
0.300	+/-0.010	3.07	✗		✓	
0.038	+/-0.010	.035	✗		✓	

Measured by:	JB	Audited by:	SD	Prototype Approval:	N/A
Date:	11-6-1	Date:	11/06/12	Date:	N/A

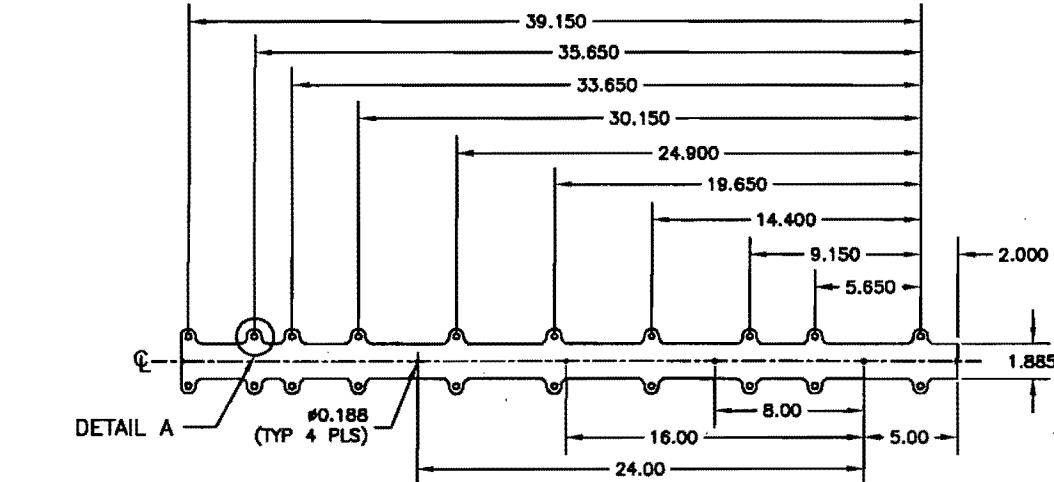
Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	EE

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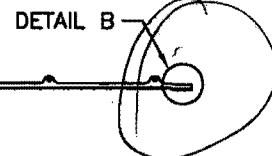
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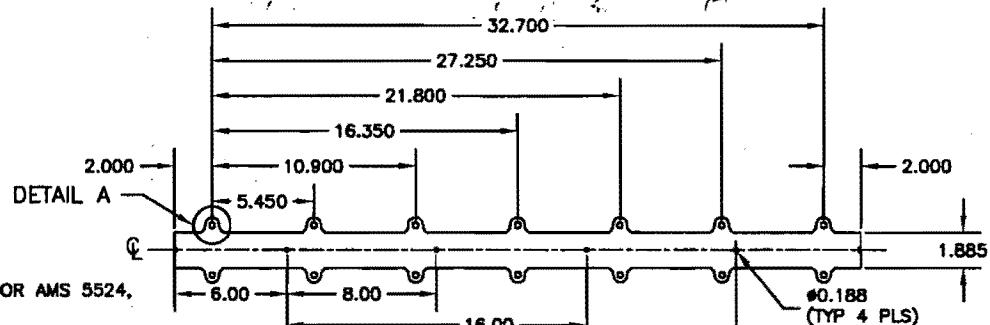


0.32
(REF)

D3535-15F BEND DETAIL

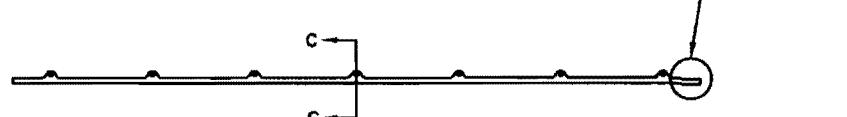


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69931
07/04/17
07/04/17
D3535-21



NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



D3535-21 BEND DETAIL

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
C.B	PH	PORT HADLOCK, WA.
CHECKED	APPROVED	DRAWING NO.
✓	✓	D3535
DATE		TITLE
07.04.17		WEARSHOE
		SCALE
		1:10

RELEASED
07.04.24
-ff-

DART

REV. B
SHEET 2 OF 7

W/O:		WORK ORDER CHANGES					
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